

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024361**Date Inspected:** 13-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite

CWI Name:	John Pagliero		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	SAS OBG	

Bridge No: 34-0006**Summary of Items Observed:**

Quality Assurance inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 9W PP76 W4 #4
2. 10W 11W C1 Diagonal Plate Splice (Inside)
3. 9W PP77 W3 Lifting Lug Holes #2 and 4
4. 9E PP79 E3 Lifting Lug Holes #2 and 4
5. 5E PP33.1 E1 Drip Rails
6. 2E PP18 Storm Ties (Temporary Catwalk)
7. 7/8" Stud Welding (Bike Path)

1. 9W PP76 W4 #4

The QA Inspector randomly observed ABF welder Fred Kaddu performing SMAW in the 1G flat position on Lifting Lug Hole (LLH) #4 located at 9W PP76 W4. The QA Inspector observed the QC Inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050-CU. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

2. 10W 11W C1 Diagonal Plate Splice (Inside)

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The QA Inspector randomly observed ABF welding operators Song Tao Huang and Jin Quan Huang performing Flux Core Arc Welding w/gas (FCAW-G) operations in the 3G vertical position on face C1 inside of the OBG. The QA Inspector observed the QC Inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. The work progressed throughout the QA Inspector's shift. The QA Inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

3. 9W PP77 W3 Lifting Lug Holes #2 and 4

The QA Inspector made periodic observations of ABF welder Darcel Jackson performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on LLH's #2 and 4 located at 9W PP77 W3. The QA Inspector observed the QC Inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

4. 9E PP79 E3 Lifting Lug Holes #2 and 4

The QA Inspector made periodic observations of ABF welder Jorge Lopez performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on LLH's #2 and 4 located at 9E PP79 E3. The QA Inspector observed the QC Inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

5. 5E PP33.1 E1 Drip Rails

The QA Inspector randomly observed ABF welder Fred Kaddu performing SMAW in the 2G horizontal position on Drip Rails at 5E PP33.1 E1. The QA Inspector observed the QC Inspector Tony Sherwood as being present in order to monitor the progress and ensure the welding parameters were in compliance with ABF-WPS-D15-F1200A. Upon completion the QC Inspector performed a Visual and Magnetic Particle test. The QA Inspector verified the testing and found the work to be free of indications and acceptable. The QA Inspector noted that the work appeared to be in general conformance with the contract documents.

6. 2E PP18 Storm Ties (Temporary Catwalk)

The QA Inspector randomly observed ABF welder Mike Jiminez performing FCAW in the 1G Flat position on the Storm Ties for the temporary "Catwalk" located at 2E PP18, 2E 3E PP19, 4E 5E PP29 (2), and 5E PP30. The QA Inspector observed the QC Inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-F2200-2. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

7. 7/8" Stud Welding (Bike Path)

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The QA Inspector randomly observed ABF operator Julian Paulk performing Stud Welding in the down hand position of 7/8 studs at the following locations; E PP33, E PP35, E PP37, E PP39, E PP41, E PP43, E PP45 (2). The QA Inspector observed the QC Inspector Tony Sherwood as being present in order to monitor the progress and ensure the welding parameters were in compliance with ABF-WPS-D15-5001 Stud. The QA Inspector noted that the work appeared to be in general conformance with the contract documents.

Summary of Conversations:

At the beginning the shift the QA Inspector met with QC Inspector John Pagliero and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
